

Date: Monday, 11/6/2006 1:48:14 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 L WEB
Job Number	: 29315		
Estimate Number	: 10722		
P.O. Number	: N/A	Part Number	: D26547
This Issue	: 11/6/2006 S.O. No. : N/A	Drawing Number	: D2654 REV E1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: E1
Previous Run	: 28934	Material	: N/A
Written By	: <i>[Signature]</i>	Due Date	: 11/30/2006
Checked & Approved By	: <i>[Signature]</i>	Qty:	4 Um: Each
Comment	: Est Rev:D 99.02.04 Fixed typo, Changed procedureDM Est Rev:e 06.04.05 Added level21 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D26007125	Extrusion 'I Beam' thick
-----	-----------	--------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2600-7- 125	Web	

321130 m-e 06/11/20 (4)

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-7 to length as per Dwg D2654 *m-e 06/11/20 (4)*

2-Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654 *m-e 06/11/20 (4)*

3-Using the uni-bit, open holes to finish size as per Dwg D2654 *m-e 06/11/21 (4)*

4-Deburr holes and ends *m-e 06/11/21 (4)*

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

Pm 06-11-21 (4)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m-e 06/11/22 (4)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *AD* Date: *06/11/23*

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 1:48:14 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L WEB

Job Number: 29315

Part Number: D26547

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BT 06-11-22

(4)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PG

BT 06 11 22

(4)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

BT 06/11/23 (4)

Job Completion



u 06.11.23

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

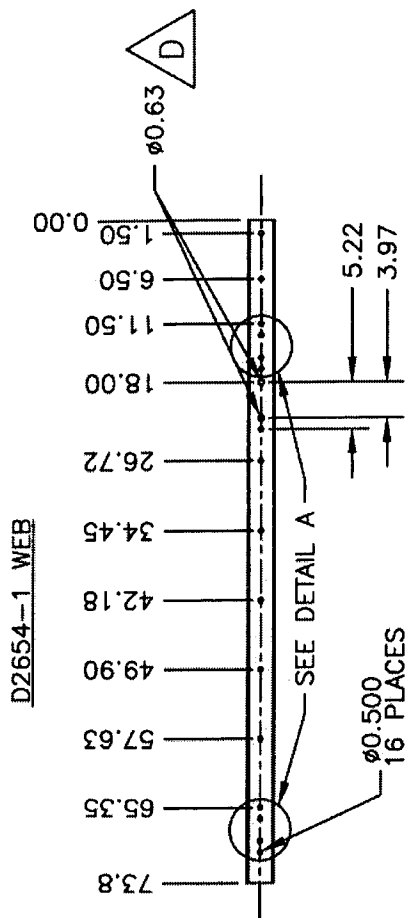
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

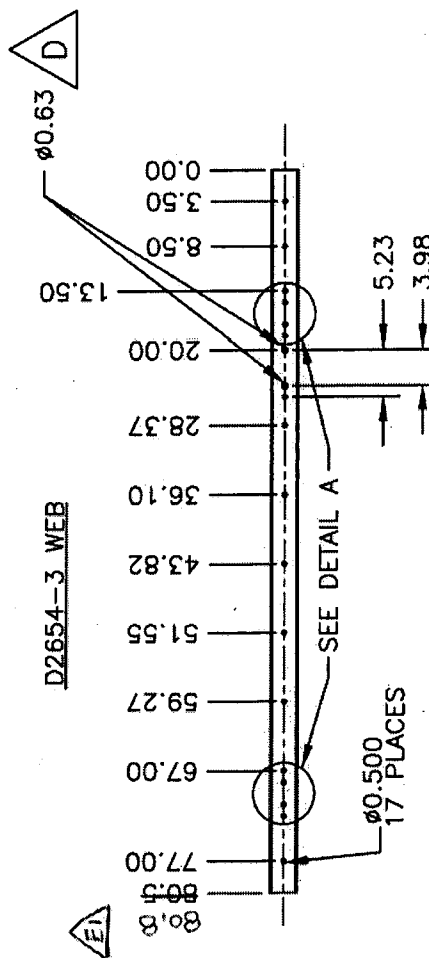
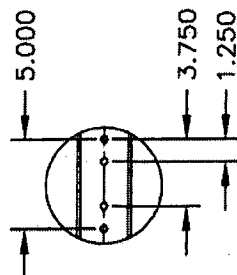


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>##</i>	APPROVED <i>##</i>	DRAWING NO. D2654	REV. E SHEET 1 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20
A	97.03.25	NEW ISSUE	
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438	
C	97.10.29	CHANGED HOLE PATTERN	
D	98.01.15	GHW HOLES CHANGED TO Ø0.63	
E	04.05.26	CHANGE LENGTHS, REFORMAT	
E1 <i>CP</i>	<i>##</i> 04.08.04	PER TOOLING; 80.8 WAS 80.5	

RELEASED
04.06.22



DETAIL A
SCALE 1:10



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29315

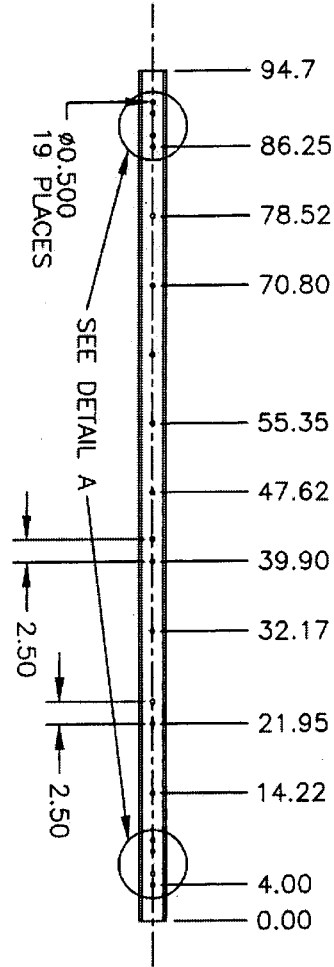
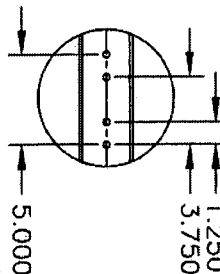
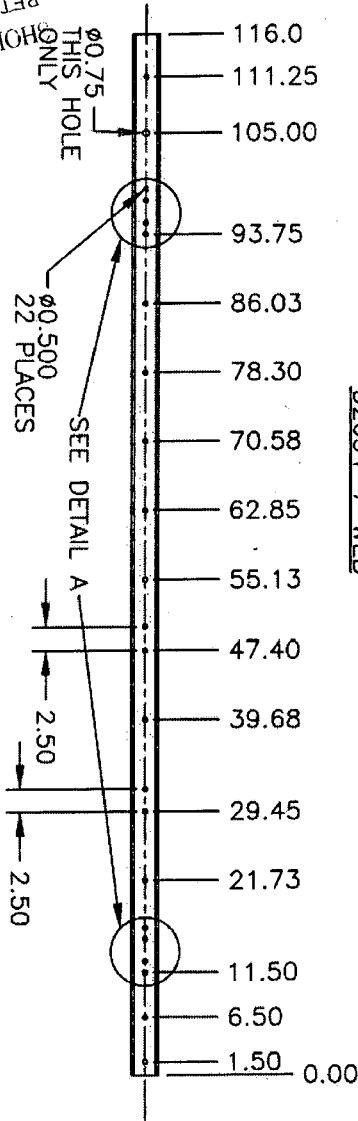
MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

NO. 29315
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
THIS HOLE
ONLY

MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



RELEASED
04.06.22

DATE	04.05.26	WEB	1:20
CHECKED		TITLE	SCALE
APPROVED		D2654	SHEET 2 OF 2
DRAWN BY		REV. E	
DESIGN		DART Aerospace USA, INC.	
		PORT HADLOCK, WA	



